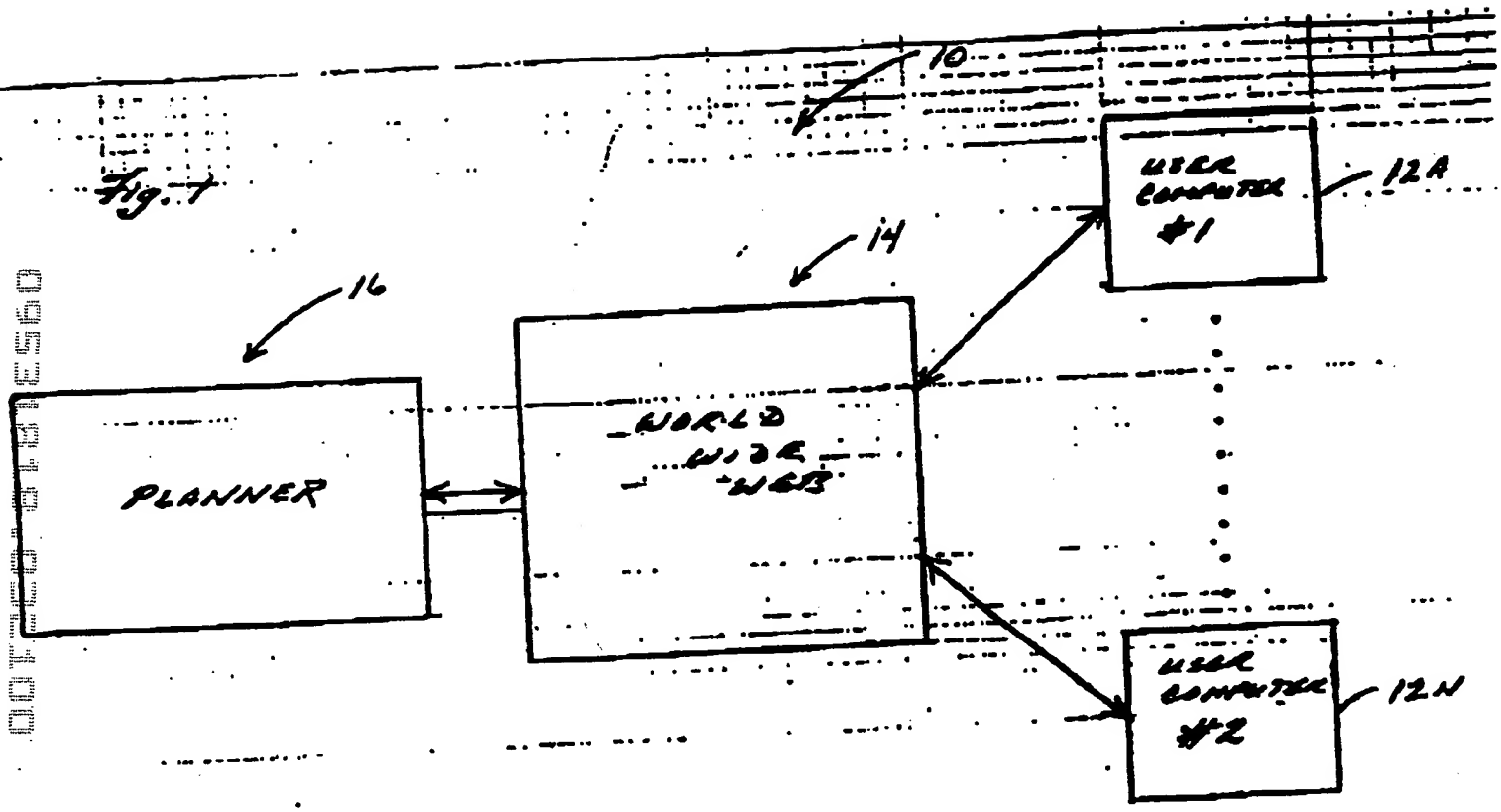

10
Fig. 1
14
16
PLANNER
WORLD
WIDE
WEB
USER
COMPUTER
#1
12A
USER
COMPUTER
#2
12N

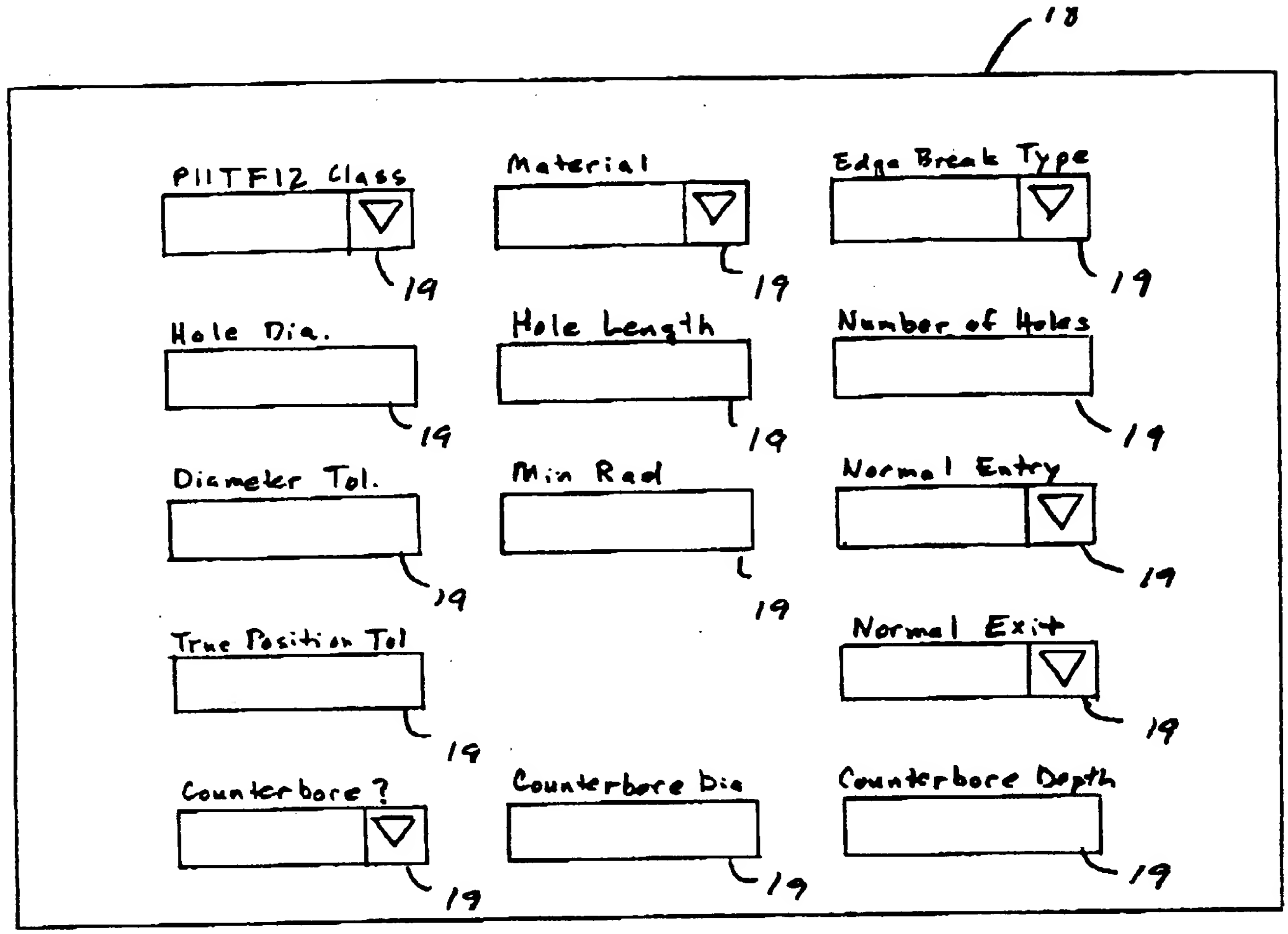
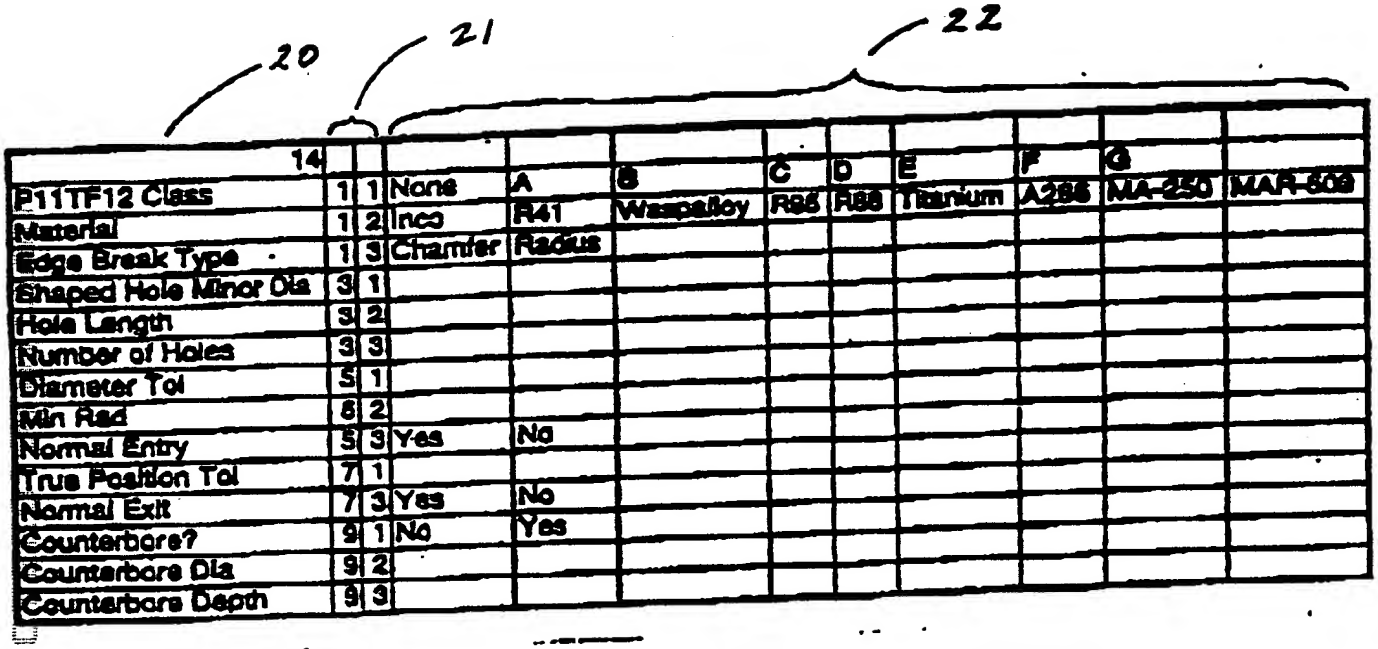


FIG. 2



14												
P11TF12 Class	1	1	None	A	B	C	D	E	F	G		
Material	1	2	Inco	R41	Waspaloy	R95	R88	Titanium	A286	MA-250	MAR-509	
Edge Break Type	1	3	Chamfer	Radius								
Shaped Hole Minor Dia	3	1										
Hole Length	3	2										
Number of Holes	3	3										
Diameter Tol	5	1										
Min Rad	5	2										
Normal Entry	5	3	Yes	No								
True Position Tol	7	1										
Normal Exit	7	3	Yes	No								
Counterbore?	9	1	No	Yes								
Counterbore Dia	9	2										
Counterbore Depth	9	3										

Fig. 3

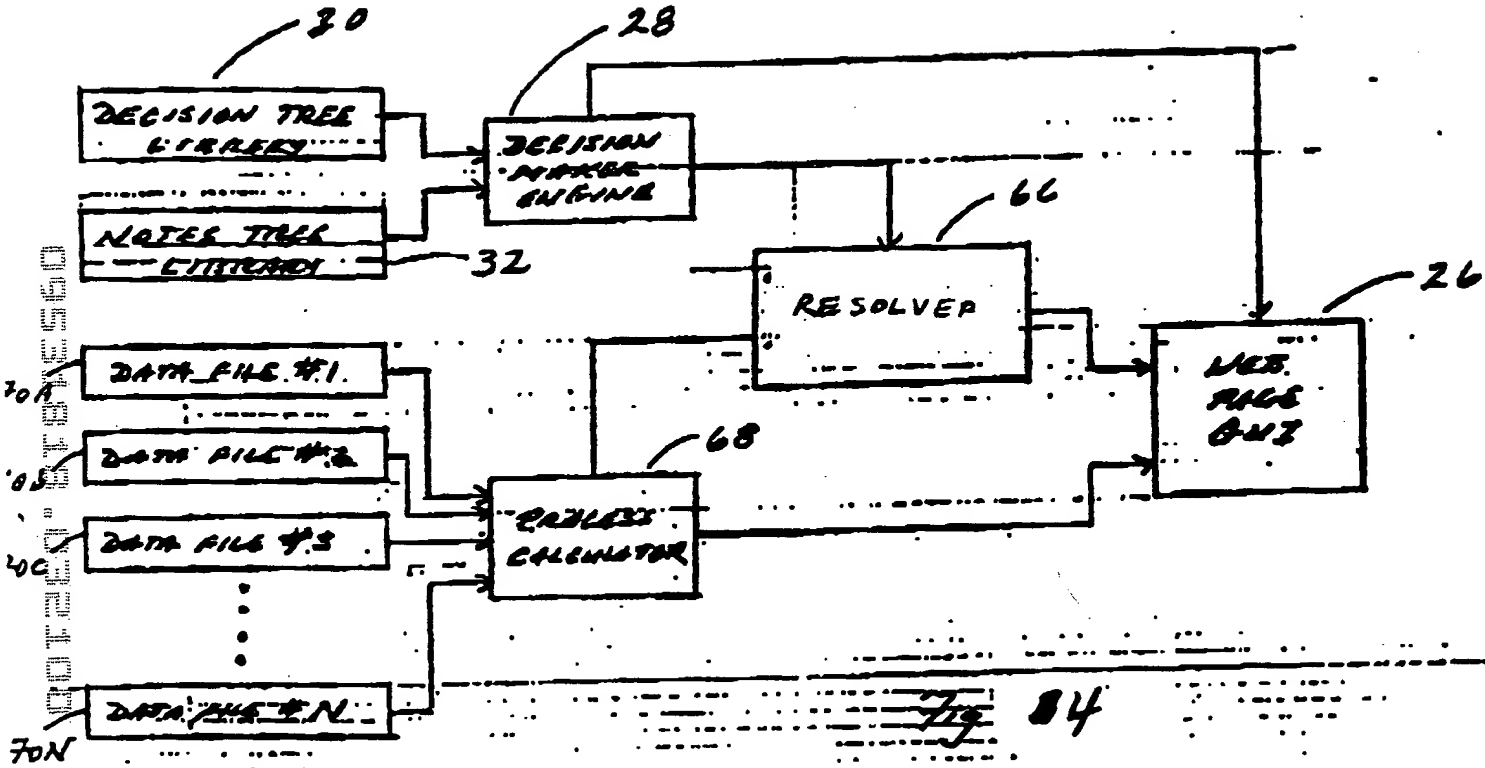

30
28
DECISION TREE LIBRARY
DECISION MAKER ENGINE
NOTES TREE LIBRARY
32
66
RESOLVER
26
WEB PAGE GUI
DATA FILE #1
70A
DATA FILE #2
DATA FILE #3
70C
68
DATA FILE #N
70N

Fig 4

NodeIndex	Type	Description	Characteristic	Operator	Value	NextNode
0	Decision	?	Normal Entry	=	No	1
						4
1	Decision	?	Shaped Hole Minor Dia	<	0.62	2
						3
						[illegible]
2	Step	Rough Endmill				4
3	Step	Endmill flat; size=.437				5
4	Step	Rough Drill; u/size=.012				6
5	Step	Finish Peripheral mill; u/size=.005				7
6	Decision	?	P11TF12 Class	=	D	8
						8
7	Step	Abrasive Flow Post-Fin; size=.001 min				9
8	Decision	?	Counterbore?	=	Yes	10
						10
9	Step	Counterbore				11
10	Step	Chamfermill top and bottom				999
11	Step	Bench edgebreak; size=320 grit b'fly				

Fig. #5

50 NodeIndex	52 Type	54 Description	56 Characteristic	60 Operator	58 Value	62 NextNode
0	Note	Use flood coolant at all times				999
4	Note	Use approximately .050 overtravel on drill stroke	filebase	contains	Thru	999
5	Note	Climb Mill while milling	process	contains	Chamfer	999
6	Note	Climb Mill while milling	process	contains	Peripheral	999
7	Note	Use one section of cutter flute for roughing; another for finishing	process	contains	Chamfer	999
8	Note	Use one section of cutter flute for roughing; another for finishing	process	contains	Peripheral	999
9	Note	Reverse flexhone spindle direction 1/2 way thru hole pattern	process	contains	Flexhone	999
10	Note	Alternate peck drill cycle: 1/2 Dia deep; retract fully; then 1/10 Dia deep; retract fully; repeat as req'd	process	contains	Coolant Fed Drill	999
11	Note	Coolant pressure of 200+ psi recommended for CF Drilling	process	contains	Coolant Fed Drill	999
14	Note	Align workpiece & spindle only after running warmup routine for this application	True Position Tol	<	0.002	999
18	Note	When shaped hole milling; rough w/ used cutter; finish with new cutter	filebase	contains	Shaped	999
19	Note	Consider Hydraulic Toolholders for this application	True Position Tol	<	0.002	999
20	Note	Align cutter flutes w/in .0002 inches before finish pass	True Position Tol	<	0.001	999

Fig. #6